

Date: Friday, 23/01/2009 8:47:52 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : CABIN DOOR ROLLER KIT, RH
 Job Number : 45198
 Estimate Number : 10289
 P.O. Number :
 This Issue : 23/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : D412698012
 First Issue : / / Type : MACHINED PARTS Drawing Number : IIN D412-698 REV E
 Previous Run : 43006 Drawing Revision : E
 Material :
 Due Date : 26/01/2009 Qty: 2 Um: Each
 Written By :
 Checked & Approved By : JUD 09.01.23
 Comment : Est Rev:C 04.02.26 Change Qty of D3121-141 & remove
 D3121-145 from Step 1,3 KJ/DS
 Est Rev:D 08-01-28 change to rev D ECN 1104 DD

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



H/La JUD 09/02/03



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D412-698-012 CHG003

S 09/02/03

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D3121141 Bracket Assembly



S Comment: Qty.: 3.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

3 D3121-141 Bracket Assembly

(4)
B42189

43484

SP

4.0 D3121144 Bracket Assembly



S Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3121-144 Bracket Assembly

(6)
B43187

B43187

SP

5.0 D3137043 Bracket Assembly



S Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

B29725

9/12/13

2x

SP

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:47:53 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CABIN DOOR ROLLER KIT, RH

Job Number: 45198

Part Number: D412698012

Job Number:



Seq. #:

Machine Or Operation:

Description :

1 D3137-043 Bracket Assembly

6.0

D3183044

Bracket Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3183-044 Bracket Assembly B42194

SV

7.0

D31991

Bracket



Comment: Qty.: 9.0000 Each(s)/Unit Total : 18.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

9 D3199-1 Bracket B42463

SP

8.0

D32021

Cover



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

1 D3202-1 Cover B40853

9/2/3

SP

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

50/62/03

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-698-012

Location: 62 RWB 9/2/3

SP

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/02/05

Job Completion



MF
0902-04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

6.0 PARTS LIST - CABIN DOOR MODIFICATION KITS

(FOR AIRCRAFT EQUIPPED WITH P/N 205-032-669-XXX ALUMINUM DOORS)

| Qty -011 | Qty -012 | Qty -013 | Qty -017 | Qty -019 | Qty -021 | Part Number | Description |
|-------------|-------------|-------------|-------------|-------------|-------------|--------------|----------------------------|
| X | | | | | | D412-698-011 | CABIN DOOR ROLLER KIT, LH |
| | X | | | | | D412-698-012 | CABIN DOOR ROLLER KIT, RH |
| | | X | | | | D412-698-013 | DOOR HANDLE KIT |
| | | | X | | | D412-698-017 | REPLACEMENT DOOR TRACK KIT |
| | | | | X | | D412-698-019 | BEARING OVERHAUL KIT |
| | | | | | X | D412-698-021 | REPLACEMENT SHIM KIT |
| 3 | 3 | | | | | D3121-141 | BRACKET ASSEMBLY |
| 1 | | | | | | D3121-143 | BRACKET ASSEMBLY |
| | 1 | | | | | D3121-144 | BRACKET ASSEMBLY |
| 1 | 1 | | | | | D3137-043 | BRACKET ASSEMBLY |
| 1 | | | | | | D3183-043 | BRACKET ASSEMBLY |
| | 1 | | | | | D3183-044 | BRACKET ASSEMBLY |
| 9 | 9 | | 9 | | | D3199-1 | BRACKET |
| 1 | 1 | | 1 | | | D3202-1 | COVER |
| | | 4 | | | | D3203-1 | HANDLE |
| | | 1 | | | | D3220-041 | DOUBLER |
| | | 1 | | | | D3220-042 | DOUBLER |
| | | 2 | | | | D3220-3 | DOUBLER |
| | | | | 7 | | D3121-21 | BOLT |
| | | | | 5 | | D3121-241 | BEARING ASSEMBLY |
| | | | | 1 | | D3137-3 | GUIDE |
| | | | | 1 | | D3137-5 | WASHER |
| | | | | 2 | | D3183-045 | BEARING ASSEMBLY |
| | | | | | 3 | D3238-1 | SHIM |
| | | | | | 1 | D3238-3 | SHIM |
| | | | | | 2 | D3238-5 | SHIM |
| | | | | | 6 | D3238-11 | SHIM |
| | | | | | 2 | D3238-13 | SHIM |
| | | | | | 4 | D3238-15 | SHIM |
| | | 8 | | | | AN960JD416L | WASHER |
| | | 8 | | | | MS21042L4 | NUT (OR MS21042-4) |
| | | 16 | | | | MS24694-S98 | SCREW |
| | | | | 1 | | MS24694-S101 | SCREW |

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Revision: E
Date: 08.05.01